

Work Order ID 69036

Wednesday, April 27, 2011 11:00:46 AM



Page 1

Item ID: D2938-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 4/27/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 6.00




Customer:

Reference:

Run Start



Approvals: Process Plan:  Date: 4-04-27 Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

| | |
|-------|-------|
| D2938 | Rev C |
|-------|-------|

| | | | | | | | | | |
|-----|--------------------------------|------|--|--|--|--|--|--|--|
| 100 | HAAS CNC VERTICAL MACHINING #1 | 0.00 | | | | | | | |
|-----|--------------------------------|------|--|--|--|--|--|--|--|



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

SL 11/05/24 (6)

| | | | | | | | | | |
|-----|------------------------------|------|--|--|--|--|--|--|--|
| 110 | CONVENTIONAL MILLING MACHINE | 0.00 | | | | | | | |
|-----|------------------------------|------|--|--|--|--|--|--|--|



Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

SL 11/05/24

6

6

| | | | | | | | | | |
|-----|--|------|--|--|--|--|--|--|--|
| 120 | QC1- Inspect dimensions to dimension sheet | 0.00 | | | | | | | |
|-----|--|------|--|--|--|--|--|--|--|



QC

Memo

0.00

Quality Control

SL 11/05/24

6

6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 69036

Wednesday, April 27, 2011 11:00:46 AM



Page 2

Item ID: D2938-2

Accept



Setup Start



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Stop



Item Name: Saddle RH Out, 206

Start Date: 4/27/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

LA 11/05/24

6 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6 BL 11-5-25

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M 11/6964

START TIME:

8:20

OVEN TEMPERATURE:

320° FINISH TIME:

8:50

6 BL 11-5-26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 69036

Page 3

Wednesday, April 27, 2011 11:00:46 AM

Item ID: D2938-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 4/27/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 0 11/05/26

170

Identify as per dwg & Stock Location: 428A

0.00



Packaging

Memo

0.00

Packaging

11/5/26 [Signature]

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/30 [Signature]11/05/26

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 27, 2011 11:00:52 AM

Page 1

Work Order ID: 69036



Parent Item: D2938-2



Parent Item Name: Saddle RH Out, 206

Start Date: 4/27/2011

Required Date: 5/3/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC
IPP Rev: C As per Rev C 07-03-19 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|-----------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|
| D6101-003 | | Manufactured | No | | | 100 | Each | 20.0000 | 1 | 6 | | | |
|-----------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|



Saddle Billet, 7075



SL 11/05/24

Location

Loc Qty

Loc Code

MAT040

20

68171

20

6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

| | |
|--|---------------------------------|
| DART AEROSPACE LTD | Work Order: <u>69036</u> |
| Description: 206 Saddle, Outboard, Right side | Part Number: D2938-2 |
| Inspection Dwg: D2938 Rev. C | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.100 | 0.140 | | .119 | .120 | .121 | .121 | | |
| B | 0.100 | 0.140 | | .119 | .120 | .121 | .121 | | |
| C | 0.100 | 0.140 | | .114 | .115 | .116 | .118 | | |
| D | 0.210 | 0.230 | | .219 | .218 | .219 | .219 | | |
| E | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | | |
| F | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | | |
| G | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| H | 0.510 | 0.515 | | .514 | .514 | .514 | .514 | | |
| I | 1.572 | 1.582 | | 1.577 | 1.577 | 1.577 | 1.577 | | |
| J | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| K | 0.257 | 0.262 | | .259 | .259 | .259 | .259 | | |
| L | 0.312 | 0.317 | | .314 | .314 | .314 | .314 | | |
| M | 0.235 | 0.240 | | .238 | .239 | .238 | .238 | | |
| N | 0.100 | 0.140 | | .108 | .116 | .119 | .119 | | |
| O | 0.540 | 0.560 | | .549 | .547 | .548 | .549 | | |
| P | 0.490 | 0.510 | | .500 | .499 | .500 | .501 | | |
| Q | 3.715 | 3.725 | | 3.720 | 3.720 | 3.720 | 3.720 | | |
| R | 2.720 | 2.760 | | 2.740 | 2.740 | 2.740 | 2.740 | | |
| S | 0.240 | 0.270 | | .249 | .250 | .249 | .251 | | |
| T | 0.100 | 0.180 | | .130 | .130 | .130 | .130 | | |
| U | 1.625 | 1.635 | | 1.630 | 1.630 | 1.630 | 1.630 | | |
| V | 1.362 | 1.372 | | 1.367 | 1.367 | 1.367 | 1.367 | | |
| W | 0.316 | 0.321 | | .317 | .317 | .317 | .317 | | |
| X | 1.250 | 1.270 | | 1.265 | 1.263 | 1.264 | 1.260 | | |
| Y | 1.565 | 1.585 | | 1.581 | 1.579 | 1.578 | 1.577 | | |
| Z | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| AG | | | | | | | | | |
| AH | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|-----------------|
| Measured by: | <u>SL</u> |
| Date: | <u>11/05/24</u> |

| | |
|-------------|-----------------|
| Audited by: | <u>B.A</u> |
| Date: | <u>11/05/24</u> |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| A | | New Issue | RF | |
| B | 02.12.12 | Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF | |
| C | 07.03.21 | Revised per drawing revision C | KJ/JLM | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | |
| Description: 206 Saddle, Outboard, Right side | | Part Number: | D2938-2 |
| Inspection Dwg: D2938 Rev. C | | Page 1 of 1 | |

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|---|---|----|------|
| Dim | Min | Max | Go/No Go Gauge | 15 | 16 | 3 | 4 | | |
| A | 0.100 | 0.140 | | .122 | .122 | | | | |
| B | 0.100 | 0.140 | | .122 | .122 | | | | |
| C | 0.100 | 0.140 | | .118 | .119 | | | | |
| D | 0.210 | 0.230 | | .218 | .220 | | | | |
| E | 1.245 | 1.255 | | 1.250 | 1.250 | | | | |
| F | 1.245 | 1.255 | | 1.250 | 1.250 | | | | |
| G | 2.495 | 2.505 | | 2.500 | 2.500 | | | | |
| H | 0.510 | 0.515 | | .514 | .514 | | | | |
| I | 1.572 | 1.582 | | 1.577 | 1.577 | | | | |
| J | 2.495 | 2.505 | | 2.500 | 2.500 | | | | |
| K | 0.257 | 0.262 | | .259 | .259 | | | | |
| L | 0.312 | 0.317 | | .314 | .314 | | | | |
| M | 0.235 | 0.240 | | .238 | .238 | | | | |
| N | 0.100 | 0.140 | | .119 | .119 | | | | |
| O | 0.540 | 0.560 | | .550 | .549 | | | | |
| P | 0.490 | 0.510 | | .502 | .501 | | | | |
| Q | 3.715 | 3.725 | | 3.720 | 3.720 | | | | |
| R | 2.720 | 2.760 | | 2.740 | 2.740 | | | | |
| S | 0.240 | 0.270 | | .251 | .252 | | | | |
| T | 0.100 | 0.180 | | .130 | .130 | | | | |
| U | 1.625 | 1.635 | | 1.630 | 1.630 | | | | |
| V | 1.362 | 1.372 | | 1.367 | 1.367 | | | | |
| W | 0.316 | 0.321 | | .317 | .317 | | | | |
| X | 1.250 | 1.270 | | 1.260 | 1.260 | | | | |
| Y | 1.565 | 1.585 | | 1.575 | 1.574 | | | | |
| Z | 0.178 | 0.198 | | .188 | .188 | | | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| AG | | | | | | | | | |
| AH | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|----------|
| Measured by: | JL |
| Date: | 11/05/24 |

| | |
|-------------|----------|
| Audited by: | H.A. |
| Date: | 11/05/24 |


| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| A | | New Issue | RF | |
| B | 02.12.12 | Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF | |
| C | 07.03.21 | Revised per drawing revision C | KJ/JLM | |

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

20  WITHOUT NOTICE
WORK ORDER

NO. 69036

R11-09-27

SECTION A-A

ENGRAVE DART LOGO TO MAX DEPTH
OF 0.005 WITH MIN RAD 0.250

— R0.250 (TYP)

— R0.525 (TYP)


CHAMFER
0.050 x 45°

VIEW C-C

D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (Q0-A-250/12)
(MAKE FROM D6101-003 SADDLE BULLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

| | | |
|----------|----------------|---|
| C | 06.11.09 | R0.188 WAS R0.30 TO R0.25 |
| B | 00.05.29 | CHANGED GEOMETRY AND MATERIAL |
| A | 99.11.12 | NEW ISSUE |
| DESIGN | DRAWN BY |  DART AEROSPACE USA, INC. BELLEVUE, WA |
| CHECKED | APPROVED | |
| DATE | TITLE | SCALE |
| 06.11.09 | SADDLE OUTSIDE | 2:3 |

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OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries